

Work Order ID 73038 *Split*

Wednesday, August 24, 2011 2:24:44 PM

Page 1

Item ID: D3512-1

Revision ID:

Item Name: Wearplate

Start Date: 8/24/2011 Start Qty: 12.00

Required Date: 8/31/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

QC:

Date: 8/24

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3512

Rev C

100



Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3512
Deburr if necessary

Dwg Rev: C Prog Rev: C 2-

B11-8-29

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-8-29

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8 wloz/30

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form as per dwg D3512 using DT8179

SB 1167107

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SB 1167107

(12)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 Qty
Description Batch A/R 2059b Hardcoat Rod M 118453

EL 119-12 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

8/24/12

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

8/24/12

Quality Control

(40)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200

9-20

10x Ø m-f 1/2" x 1/4"

M 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 8/24/2011 Start Qty: 12.00

Required Date: 8/31/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10
counted
2 measured

11-09-14

200



Packaging

Packaging

Identify as per dwg & Stock Location: 5150

Memo

0.00

0.00



11-09-14

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/9/15

MF 11-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 24, 2011 2:24:53 PM

Work Order ID: 73038

Parent Item: D3512-1

Parent Item Name: Wearplate



Page 1

Start Date: 8/24/2011

Required Date: 8/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM
 IPP Rev:B Now SS as per Rev B 06-12-15 JLM
 IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	203.6000	0.261	3.296842			

304/316 Sheet .063



1311-E-X

Location

MAT020

118578

MAT021

118217

Loc Qty

120

120

83.6

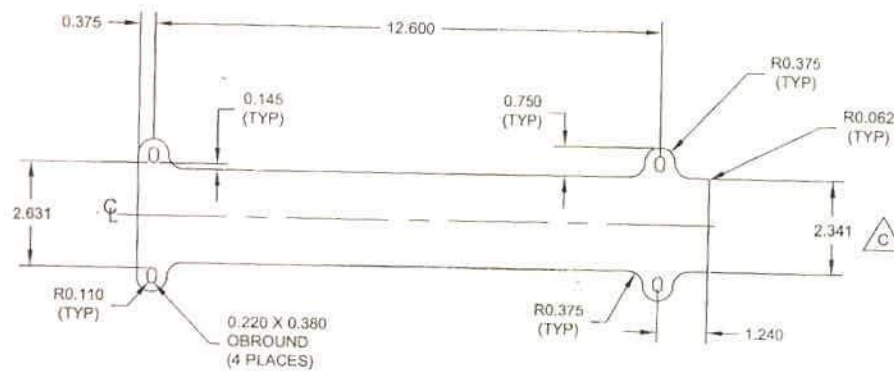
83.6

Loc Code

48578

(12)

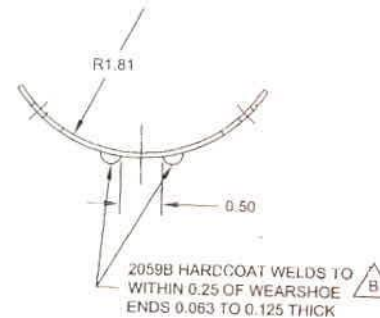
FIRST ARTICLE INSPECTION CHECKLIST



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3512 TITLE: WEARPLATE SCALE: 1:3 REV. C SHEET 1 OF 1 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS SUPPLIED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.10.05		

RELEASED
07-11-16